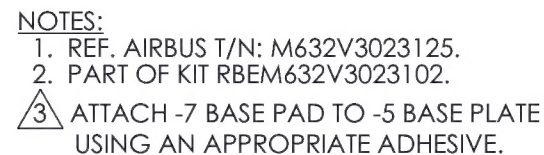


REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	7/19/2016	DPD	JAG



TITLE
UPPER SERVO CONTROL AXLE EXCHANGE

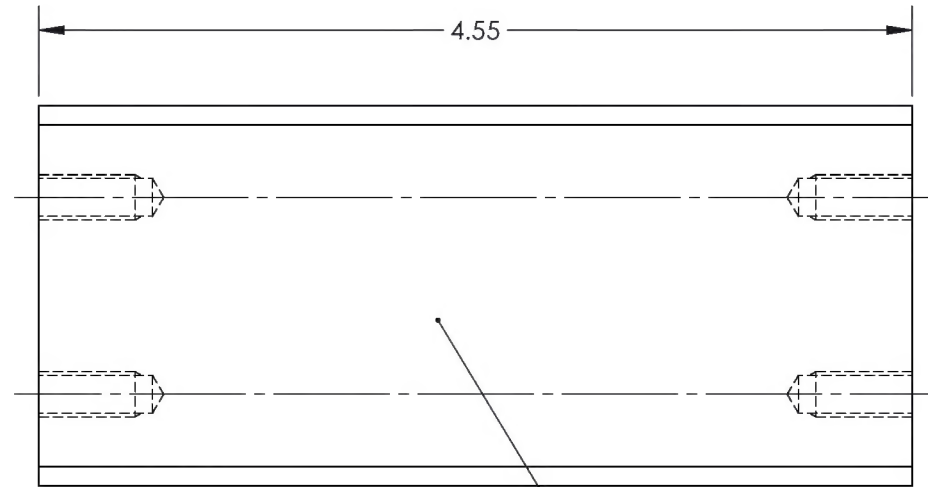
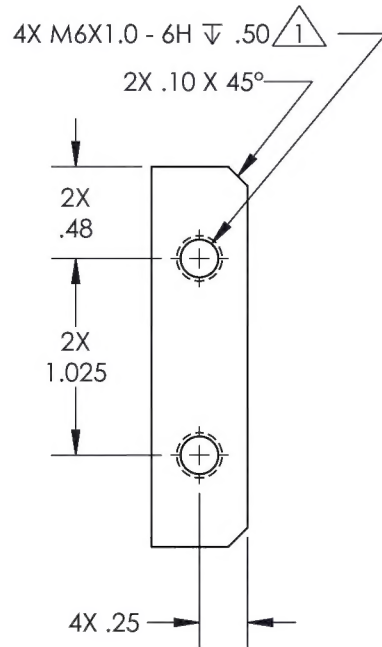
DWG NO.	RBEM632V3023125	REV 1
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									RBEM632V3023125				1
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.	MAT'L		UNLESS OTHERWISE SPECIFIED		
			-1	1	BACK PLATE	A36/1018/1020 HR		2	HEAT TREAT FINISH	DIMENSIONS ARE IN INCHES			
			-3	1	THREADED PLATE	A36/1018/1020 HR		3	SPEC	.XXX ± .005 FRACTIONS ± 1/8			
			-5	1	BASE PLATE	A36/1018/1020 HR		4	DRAWN BY: DUERFELDT	.XX ± .01 ANGLES ± 5°			
			-7	1	BASE PAD	WHITE DELRIN		5	CHECKED: MACKOVJAK	.X ± .1 SURFACES = 125°			
			-9	1	FOOT	1018/1020 CR		6	OPPS APPR: ANDERSON	1. BREAK ALL SHARP EDGES			
		B/O	-11	1	HEX HEAD CAP SCREW	S.S.	M8 X 1.25mm X 120mm (MCMASTER-CARR #91287A461)	1	QA APPR: LINDSAY	.015 x 45° OR .015R			
		B/O	-13	4	SOCKET HEAD CAP SCREW	S.S.	M6 X 1mm X 25mm (MCMASTER-CARR #91292A138)	1	APPROVED: GILBERT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
									SCALE 1:2	DATE 3/24/2016	SHEET 1 OF 6		

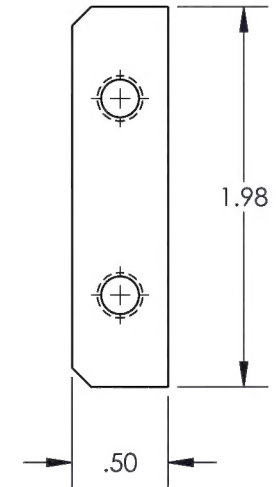
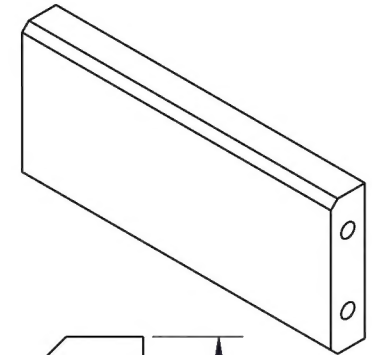
SHEET 1 OF 6

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



INK STAMP T/N, S/N,
"MADE IN USA"



NOTE:

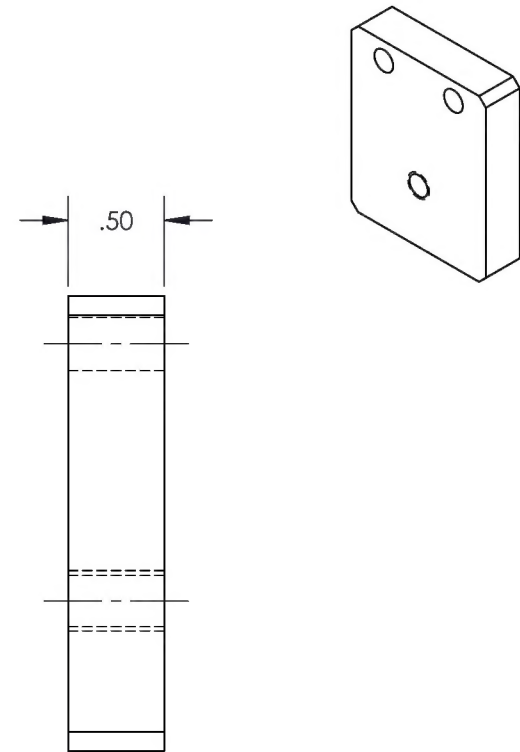
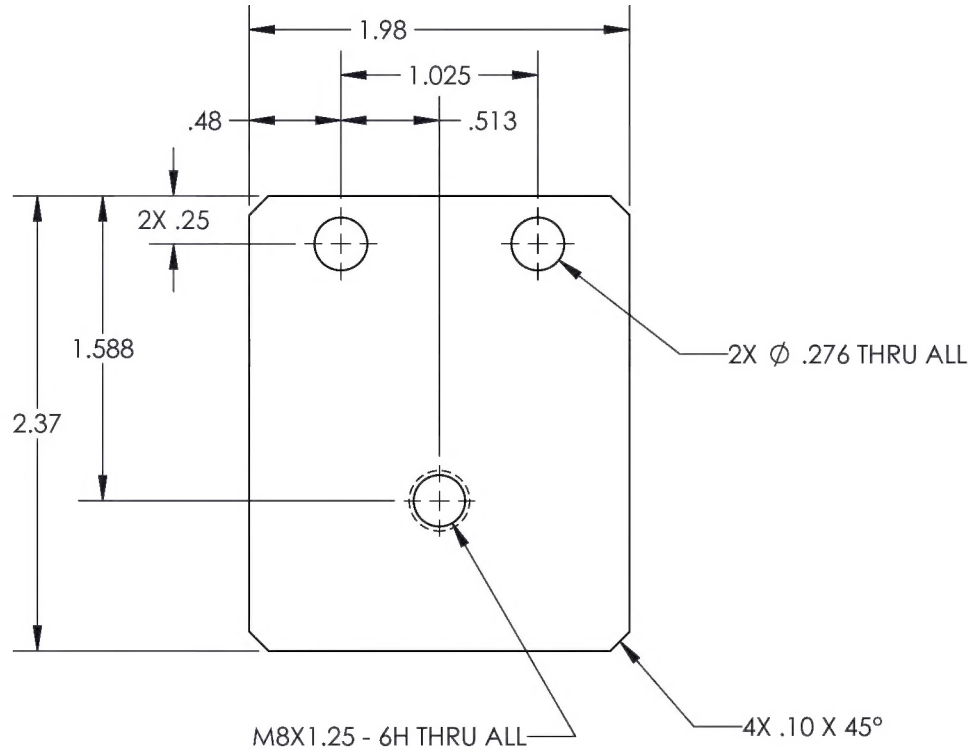
¹ NO POWDERCOAT THIS SURFACE.

(-1)
BACK PLATE

DART AEROSPACE	
TITLE UPPER SERVO CONTROL AXLE EXCHANGE	
DWG NO. RBEM632V3023125-1	REV 1
MAT'L A36/1018/1020 HR HEAT TREAT FINISH POWDER COAT YELLOW SPEC FED #13538	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	USED ON MODEL
CHECKED: MACKOVJAK	H175
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:1	DATE 3/24/2016
SHEET 2 OF 6	

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



M8X1.25 - 6H THRU ALL

4X .10 X 45°

2X Ø .276 THRU ALL

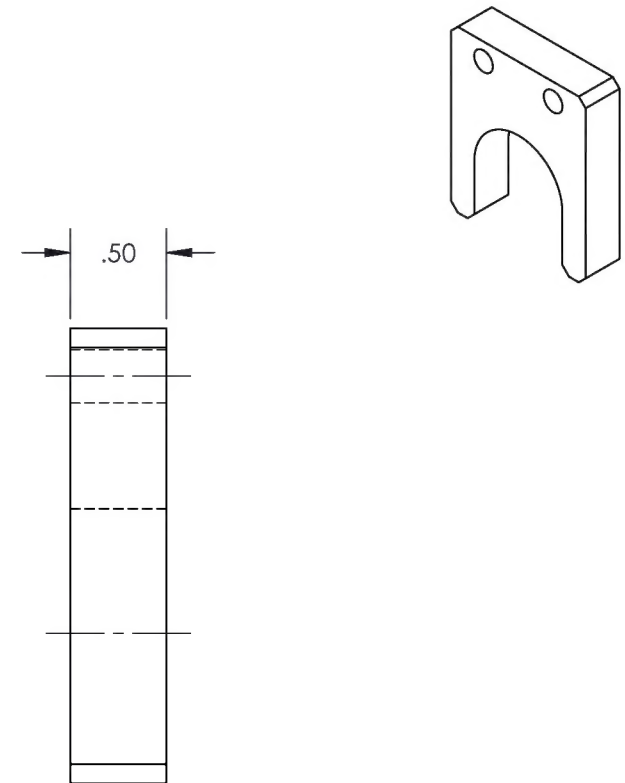
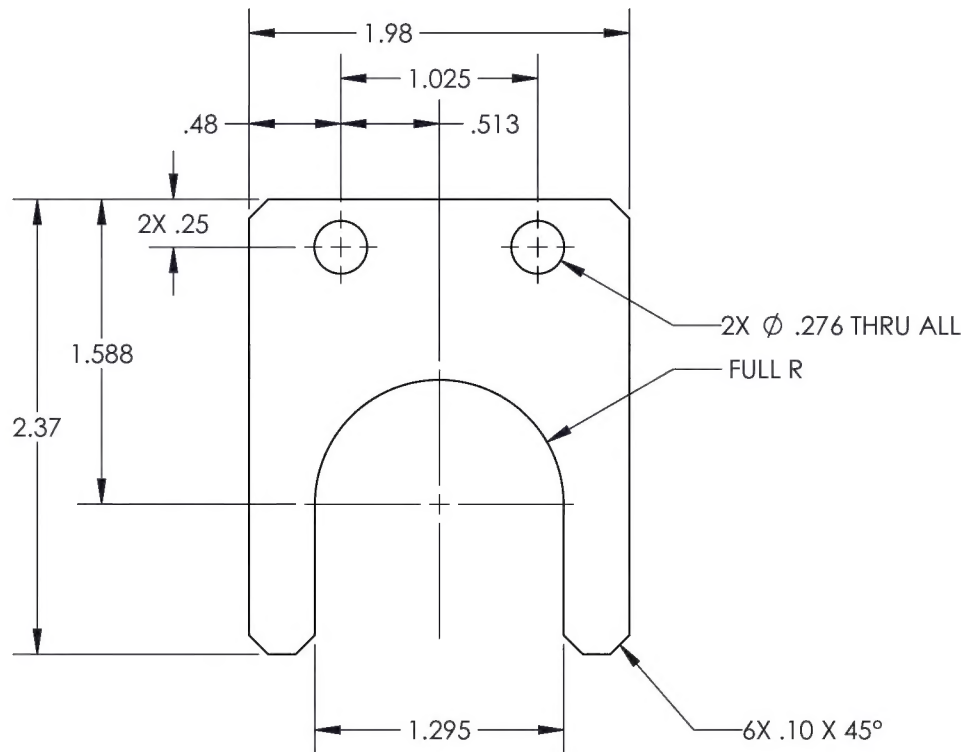
(-3)

THREADED PLATE

DART AEROSPACE	
TITLE UPPER SERVO CONTROL AXLE EXCHANGE	
DWG NO. RBEM632V3023125-3	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH POWDER COAT YELLOW	.XXX ± .005 FRACTIONS ± 1/8
SPEC FED #13538	.XX ± .01 ANGLES ± .5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125° ✓
CHECKED: MACKOVJAK	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:1	DATE 3/24/2016
	SHEET 3 OF 6

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

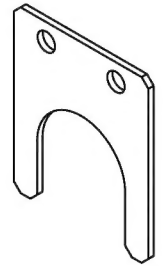
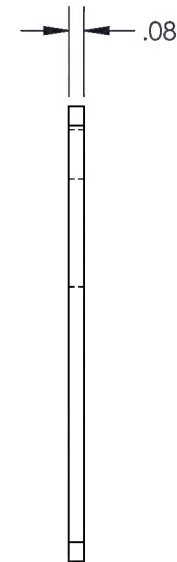
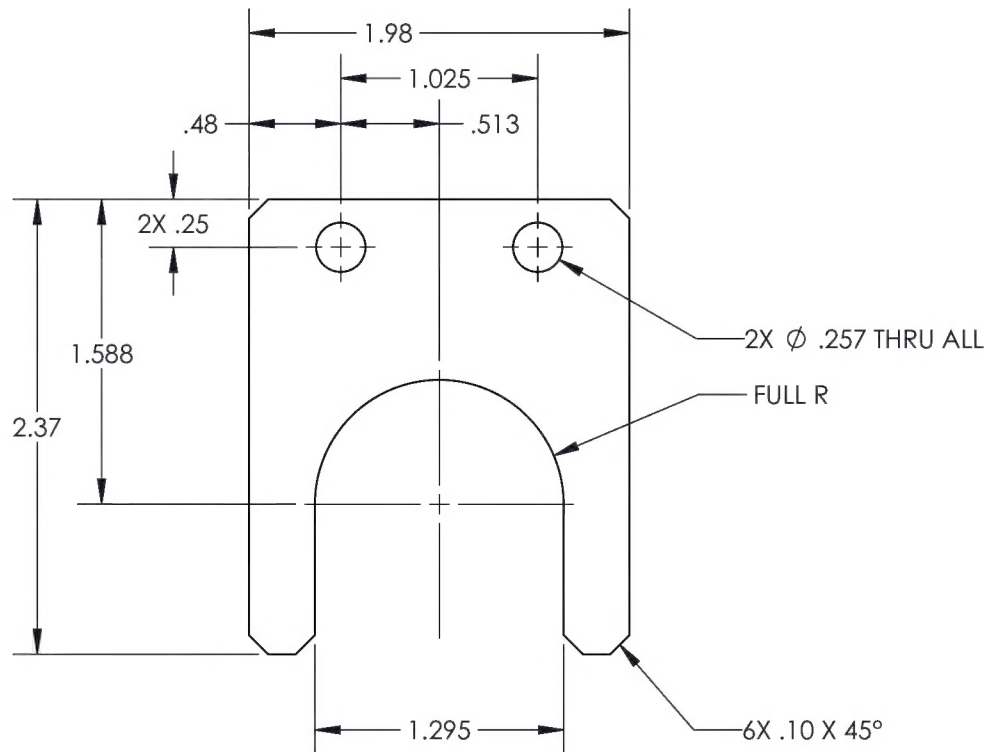


(5)
BASE PLATE

DART AEROSPACE	
TITLE UPPER SERVO CONTROL AXLE EXCHANGE	
DWG NO. RBEM632V3023125-5	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH POWDER COAT YELLOW	.XXX ± .005 FRACTIONS ± 1/8
SPEC FED #13538	.XX ± .01 ANGLES ± 5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125°
CHECKED: MACKOVJAK	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:1	DATE 3/24/2016
	SHEET 4 OF 6

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

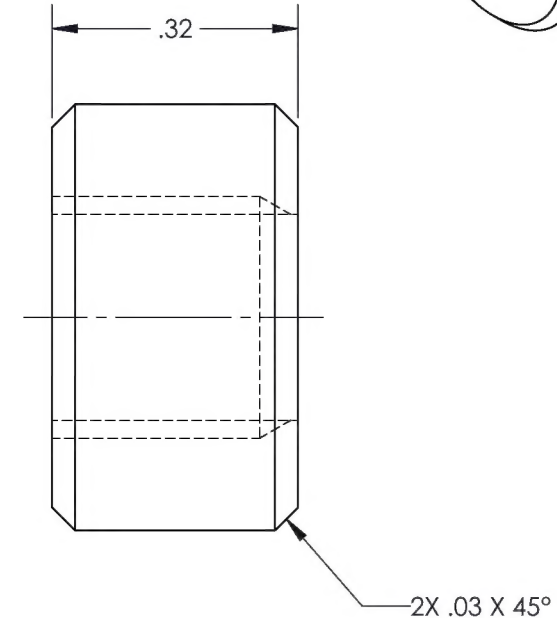
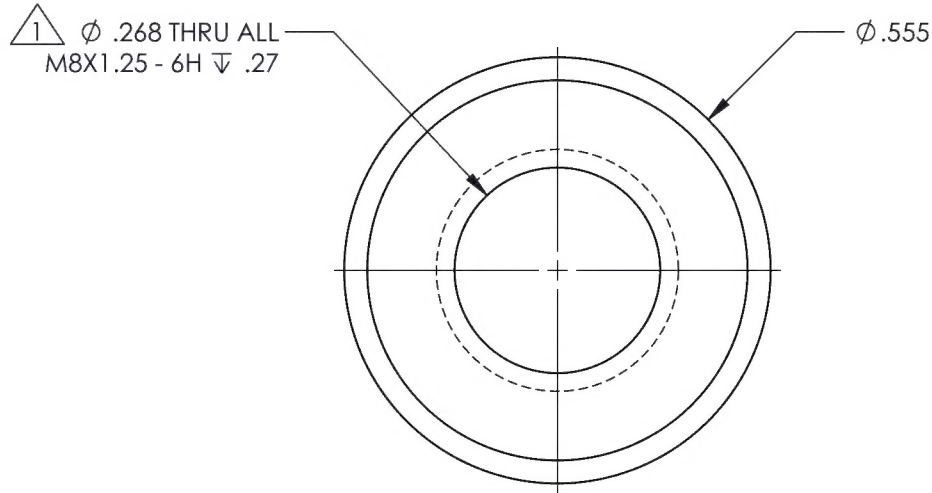
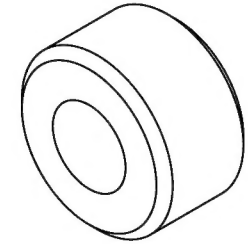


(-7)
BASE PAD

DART AEROSPACE	
TITLE UPPER SERVO CONTROL AXLE EXCHANGE	
DWG NO. RBEM632V3023125-7	REV 1
MAT'L WHITE DELRIN	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: MACKOVJAK	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	H175
SCALE 1:1	DATE 3/24/2016
	SHEET 5 OF 6

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	



NOTE:

1 NO POWDER COAT THIS SURFACE.



TITLE
UPPER SERVO CONTROL AXLE EXCHANGE

DWG NO. RBEM632V3023125-9 REV 1

MAT'L 1018/1020 CR		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH POWDER COAT YELLOW		.XXX ± .005	FRACTIONS ± 1/8
SPEC FED #13538		.XX ± .01	ANGLES ± .5°
DRAWN BY: DUERFELDT		.X ± .1	SURFACES = 125 ✓
CHECKED: MACKOVJAK		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 4:1		3. INTERPRET DIM AND TOL PER	
DATE 3/24/2016		ASME Y14.5M-2009	
		USED ON MODEL	
		H175	
		SHEET 6 OF 6	

(-9)
FOOT